

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008947**Date Inspected:** 30-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as OBG 2AE. The weld designations reviewed are as follows:

2AE

1. SEG008E-041, 042, 050, 014, 022
2. SSD56A-PP14.5-168
3. SEG008F-165, 166, 066, 067, 138, 139, 129, 130, 043, 102, 103, 093, 094, 173, 164, 065, 155, 146
4. SEG008F-173, 164, 065, 155, 146, 101, 092, 019, 074,
5. SSD24-PP14.5-170
6. SEG008-043, 044, 052, 016, 017, 176, 177, 167, 168, 158, 159, 140, 141, 131, 132, 104, 105, 095, 096
7. SSD56-PP14.5-217
8. SSD24-PP15.5-171
9. FB038-001-128, FB022-001-128, FB026-001-128
10. BP026-001-24~31, 34, 35, 38, 39, 42, 43

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

1AE & 1BE

SMAW welding of weld joint 008 located on OBE1A.

Welder is identified as Mr. Zang Yanbo (045196). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G (1F)-FCM-Repair and repair procedure B-WR7255.

5BE & 5CE

FCAW welding of weld splice joint 009 located on OBE5A.

Welder is identified as Mr. Zhao Pan (220063). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231T.

FCAW welding of weld splice joint 006 located on OBE5A.

Welder is identified as Mr. Chen Zhenghua (220067). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231T.

1AE

FCAW welding of weld joint 003 located on SSD34-PP8.5.

Welder is identified as Mr. Yun Chuanshan (050316). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4b-FCM.

FCAW welding of weld joint 003 located on SSD34-PP8.5.

Welder is identified as Mr. Ji Hongwei (058245). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4b-FCM.

5BE

SMAW welding of X37K angles located between panel point 33 & 34 located on the cross beam side.

Welder is identified as Mr. Wang Zhengbin (216086). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G (1F)-Repair, WPS-345-FCAW-3G (3F)-Repair and repair procedure B-WR6249.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
